

Date: Tuesday, 6/19/2007 2:19:15 PM
 User: Kim Johnston

Process Sheet

27

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 32990	
Estimate Number : 10503	
P.O. Number :	Part Number : D2745
This Issue : 6/19/2007 S.O. No. :	Drawing Number : D2745 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 31697	Material :
Written By :	Due Date : 7/1/2007 Qty: 150 Um: Each
Checked & Approved By : <u>1807.06-20</u>	
Comment : Est C 02.03.07 Update to turn in house NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R0750	303 Round Bar .75"
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Comment: Qty.: 0.1007 f(s)/Unit Total : 15.1043 f(s)
 303 ROUND .75"
 Machine per Folio FA201 Material: AISI 303 SS

Batch: M105801

DIP 07/10/13

(150)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 1-Turn as per Dwg D2515
 2-Deburr

DIP 07/10/13

(150)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP 07/10/13

(150)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

DIP 07-10-15

(150)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 N/A - deburr any sharp edges as per dwg

DIP 07-10-15

(150)

6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

DIP 07/10/15

(150)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BUSHING

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Part Number: D2745

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5748

07/10/16

(150)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



07.10.16

A

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07/10/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

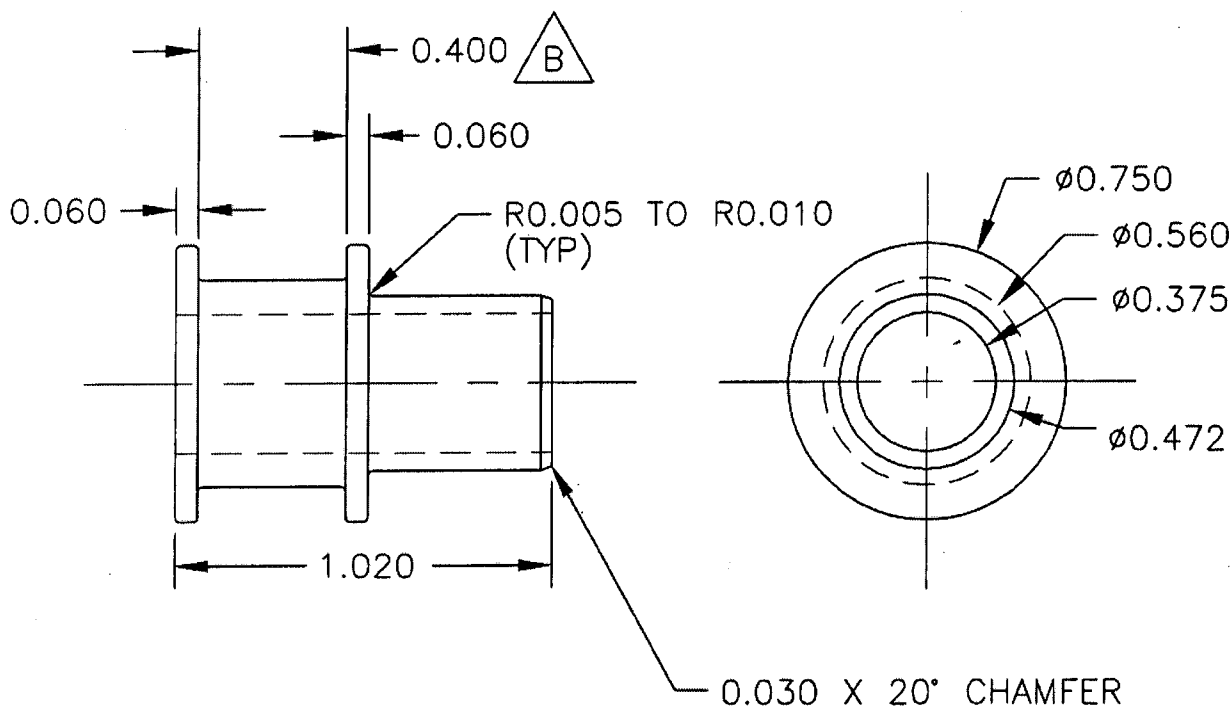
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>HA</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>HA</i>	APPROVED <i>KE</i>	DRAWING NO. D2745	REV. B SHEET 1 OF 1
DATE 98.10.23		TITLE BUSHING	SCALE 2:1
A	98.04.16	NEW ISSUE	
B	98.10.23	DIM 0.400 WAS 0.380	

RELEASED
98.11.03 DS



MATERIAL: AISI 303 STAINLESS STEEL

NOTES: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RADIUS ALL INSIDE EDGES 0.005 TO 0.010

BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020

ALL DIMENSIONS ARE IN INCHES

WORK COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32990